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E-5 (Rev. 10/15/02) \*LOCATION 7540

The discharged molding sand from the nozzles is introduced into a mold space defined by the pattern plate, the filing frame, and the squeeze feet. The squeeze feet then compact the molding sand.

Two of the upwardly-extending cylinders may be located on corners of one diagonal line on the base. In this case, two other upwardly-extending cylinders may be located on corners of another diagonal line on the base. That is, the four cylinders acting as the rod-like elements may be employed. Alternatively, a pair of holders, each of which has vertically slidable guide pins fitted therein, may be located on the corners of the second diagonal line on the base.

The rod-like elements may be three upwardly-extending cylinders that are arranged to form a triangle on the base. In this case, the carrying means can be a turntable that rotates around the one cylinder, which as the vertex of the triangle forms the axis of rotation.

In each embodiment, separated and vertically-movable squeeze feet may be employed. The squeeze surface that is formed by the lower ends of the squeeze feet may have a protruding or receding profile when the mold space is being formed, and may have a planer profile when the compacting is completed.

#### Brief Description of the Drawings

The accompanying drawings, which are incorporated in and constitute a part of the specification, schematically illustrate a preferred embodiment of the present invention, and together with the general description given above and the detailed description of the preferred embodiment given below serve to explain the principles of the invention.

Fig. 1 is a schematic, elevational, and sectional view of the apparatus of the first embodiment of the present invention.

Figs. 2 to 6 are schematic, elevational and sectional views of the apparatus of Fig. 1 to explain the operations of it.

Fig. 2 shows the step where a mold space to mold a sand mold is defined.

Fig. 3 shows the step where molding sand is introduced into the mold space.

Fig. 4 shows the step where the molding sand in the mold space undergoes the first squeeze.